Work Order ID 61474
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Thursday, August 26, 2010 2:38:51 PM



Page 1

Item ID:

D412-742-043

Accept



Setup Start

Stop



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**Revision ID:** 

Item Name:

Replacement Float Skidtube

**Start Date:** 

8/26/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Reference:

Required Date: 9/6/2010

Approvals:

**Process Plan:** 

Date: 10-8-24 Tooling:

Date:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run

Start Stop



Sequence ID/

Operation

Set Up/

Tool # Plan

Accept

Reject

Insp.

**Work Center ID** Draw Nbr

Description

**Revision Nbr** 

**Run Hours** 

Tool ID

Qty Code

Qty

Reject Number

Stamp

D3391

100

Rev H

DOCUMENT CONTROL

Memo

Document Control

If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG004

Dart Aerospace L	Lta
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W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:							
NCR:				ER NON-CONFORMAN					
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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#### Work Order ID 61474

Thursday, August 26, 2010 2:38:51 PM



Page 2

Insp.

Stamp

D412-742-043 Item ID: Accept Setup Start Revision ID: Stop Item Name: Replacement Float Skidtube **Start Date:** 8/26/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 9/6/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date:\_\_\_\_\_ Process Plan: **Tooling:** Approvals: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): OC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number 110 0.00 HandFinishing => M 10/09/01 HandFinish Hand Finishing 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment, using 7/16" "T" Pins. Expiry date: \(\(\)\(\)\(\) 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.  $A/R \square \square Sikaflex-241/-291 \square N/()(SI)$ Expiry date:

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with

Remove "T" pins once sikaflex is dry.

A/R DLPS Procyon | /1/1/ 596

MEK degreaser.

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
10.09.01	110	Acceptable to file inner holes to allow saddle holes to align.	Q,	10/09/01	1 '	10.09.61 081 042						

Part No: _	· · ·	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

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#### Work Order ID 61474

Thursday, August 26, 2010 2:38:51 PM



Page 3

Item ID:

D412-742-043

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Replacement Float Skidtube

8/26/2010

Start Oty: 1.00

Required Date: 9/6/2010

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

130

Packaging

Packaging

140

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES											
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### **Picklist Print**

Thursday, August 26, 2010 2:38:56 PM

Work Order ID: 61474

Parent Item: D412-742-043

Parent Item Name:

Replacement Float Skidtube

**Start Date: 8/26/2010** 

Required Date: 9/6/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

As per Rev F IPP Rev:C 07-05-28

IPP Rev:D 07-12-04

ECN 1072

JLM DD verified by:JLM

KJ/JLM□

EC

IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 	<b>*</b> ?	Purchased	No			110	Each	1,769.000	1 (88) (180)	24 YL X	rologl	01	
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Thursday, August 26, 2010 2:38:56 PM

Work Order ID: 61474 Parent Item: D412-742-043 Parent Item Name: Replacement Float Skidtube Start Date: 8/26/2010 Required Date: 9/6/2010 Start Qty: 1.00 Required Qty: 1.00 AN3C7A Purchased No 110 Each 174.0000 **BOLT** Location Loc Oty Loc Code ST351 174 105906 107376 113149 121 114382 45 AN960C10L NAS1149C0332 Purchased No 110 Each .155.0000 M 115000 washer Location Loc Oty Loc Code ST245 155 107534 29 109545 54 111548 72 D3391-021 + 0.0000 Each

Fwd Tube Assembly D3391-023

Mid Tube Assembly

Manufactured

110

Each

1.0000

1356618 XI H 10109101

Location Loc Qty Loc Code FP 40522

W/O:		WORK ORDER CHANGES												
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# **Picklist Print**

Page 3

· Thursday, August 26, 2010 2:38:56 PM

Work Order ID: 61474  Parent Item: D412-742-043  Parent Item Name: Replacement Float Skidtube  Start Date: 8/26/2010 Required Date: 9/6/20  Start Qty: 1.00 Required Qty: 1.00	010
Parent Item Name:         Replacement Float Skidtube         Start Date: 8/26/2010         Required Date: 9/6/2010           Start Qty: 1.00         Required Qty: 1.00           D3391-025         Manufactured         No         110         Each         1.0000         1         1	010
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Trialitatetated 1.000 1	
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. 48122 1 D3564-1	
D3564-1 Manufactured No 110 Each 17.0000 1 1	
Location Loc Oty Loc Code	
FG 2	
33798 2	
FP 3	
<u>(1676)</u> 3	
FP19 12 <u>X\</u> 58823 12	
D3564-3 Manufactured No 110 Each 16.0000 1 1	
Wearshoe  Wearshoe	(
Location Loc Qty Loc Code	
FG 2	
33764 2	
FP19 14	
55489 2 2 12	

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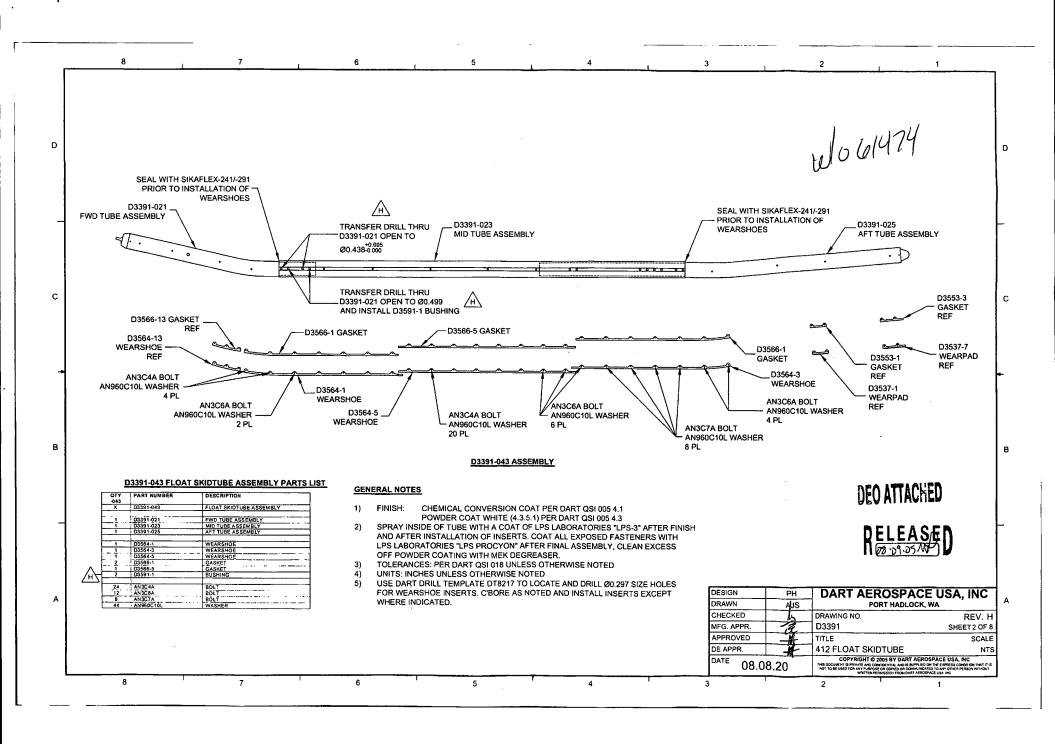
· Thursday, August 26, 2010 2:38:56 PM Work Order ID: 61474 Parent Item: D412-742-043 Parent Item Name: Replacement Float Skidtube **Start Date: 8/26/2010** Required Date: 9/6/2010 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured No 110 20.0000 Each 10/09/01 Wearshoe Location Loc Qty Loc Code FG 34806 FP19 57525 58709 FP-19 17 6 11 D3566-1 Manufactured No 110 Each 27.0000 rologlor Gasket Location Loc Qty Loc Code FP 3 60857 3 FP015 24 57715 2 60202 12 61215 10 D3566-5 Manufactured No 110 Each 29.0000 10/09/01 Gasket

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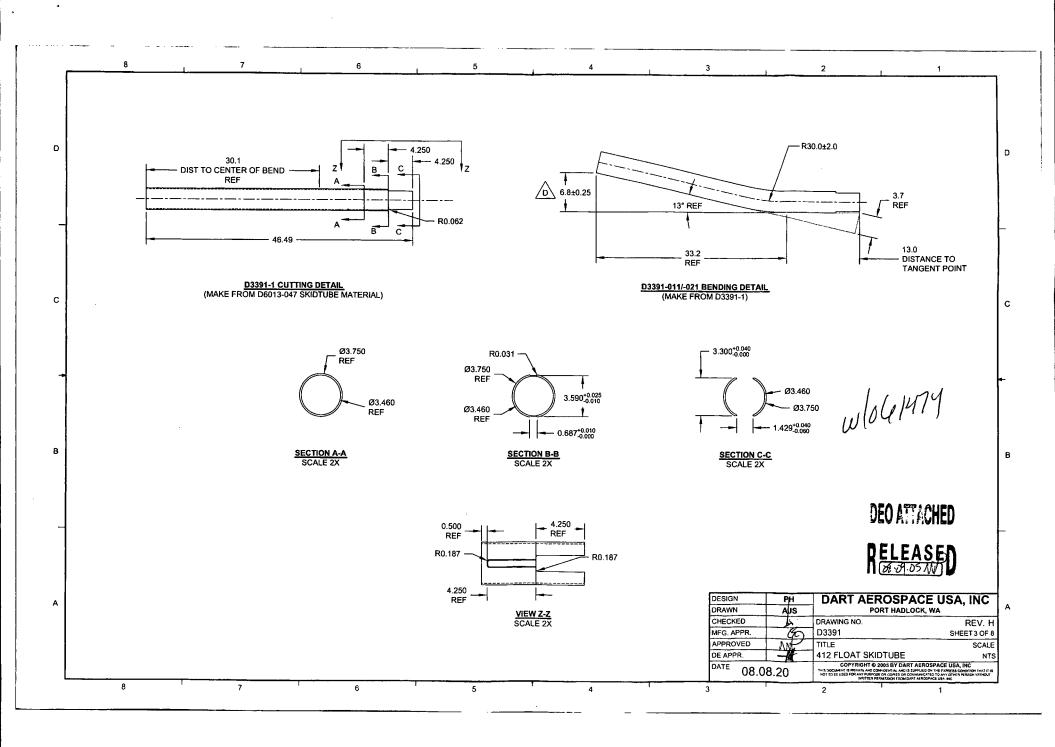
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ENCINE, R. 33 TIME CAPPOOR HE SENANTY SUBJECT: OF AMENDMENT WITTEN T NOTE & WORK GRD.-R SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF n WEARSHOES MS27039C4-12 SCREW D3391-011 SEAL WITH SIKAFLEX-241/-291 FWD TUBE ASSEMBLY **D3672-3 WASHER** PRIOR TO INSTALLATION OF D3391-013 AN960C416L WASHER D3391-015 TRANSFER DRILL THRU WEARSHOES MID TUBE ASSEMBLY AFT TUBE ASSEMBLY D3391-011 OPEN TO Ø0.438-0.005 TRANSFER DRILL THRU D3553-3 -D3391-011 OPEN TO Ø0.499 H GASKET AND INSTALL D3591-1 BUSHING REF D3566-13 GASKET D3537-7 - D3566-5 GASKET -D3566-1 GASKET WEARPAD D3564-13 WEARSHOE REE D3566-1 c REF GASKET D3553-1 GASKET D3564-3 AN3C4A BOLT (1) WEARSHOE AN960C10L WASHER (1) D3564-1 A PI WEARSHOE AN3C6A BOLT AN3C6A BOLT (1) AN3C4A BOLT (1) AN3C6A BOLT D3564-5 AN960C10L WASHER AN960C10L WASHER (1) AN960C10L WASHER AN960C10L WASHER (1) WEARSHOE 4 PL 20 PL 6 PL AN3C7A BOLT -AN960C10L WASHER 8 PL **D3391-041 ASSEMBLY** DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0,438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. 08.08.20 SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL, ADDED Ø0,499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING 07.07.31 DC FLOAT BAGS, DWG REORGANIZED FOR CLARITY ADD SS WEARSHOE, GASKET **D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST** 07.01.18 REMOVE FWD SADDLE HOLE -011/-021 PH QTY -041 **GENERAL NOTES** CHANGE TO FRANCE EASE MANUFACTURE E PH 06.04.25 D UPDATE TOLERANCE, CHANGE HOLE SIZE PH 06.01.23 CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 FWD TUBE ASSEMBLY c LENGTHEN AFT EXTENSION PH 05.09.27 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 В DRAWING UPDATES PH 05.06.10 SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS, COAT ALL EXPOSED FASTENERS WITH A NEW ISSUE PH 05.02.07 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS DESCRIPTION REV. BY DATE OFF POWDER COATING WITH MEK DEGREASER. DESIGN PH DART AEROSPACE USA, INC TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED PORT HADLOCK, WA DRAWN UNITS: INCHES UNLESS OTHERWISE NOTED CHECKED DRAWING NO. REV. H USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS, C'BORE AS NOTED AND INSTALL INSERTS EXCEPT MFG. APPR D3391 SHEET 1 OF 8 WHERE INDICATED. APPROVED TITLE SCALE DE APPR 412 FLOAT SKIDTUBE NTS COPYRIGHT @ 2005 BY DART AEROSPACE USA, INC DATE 08.08.20

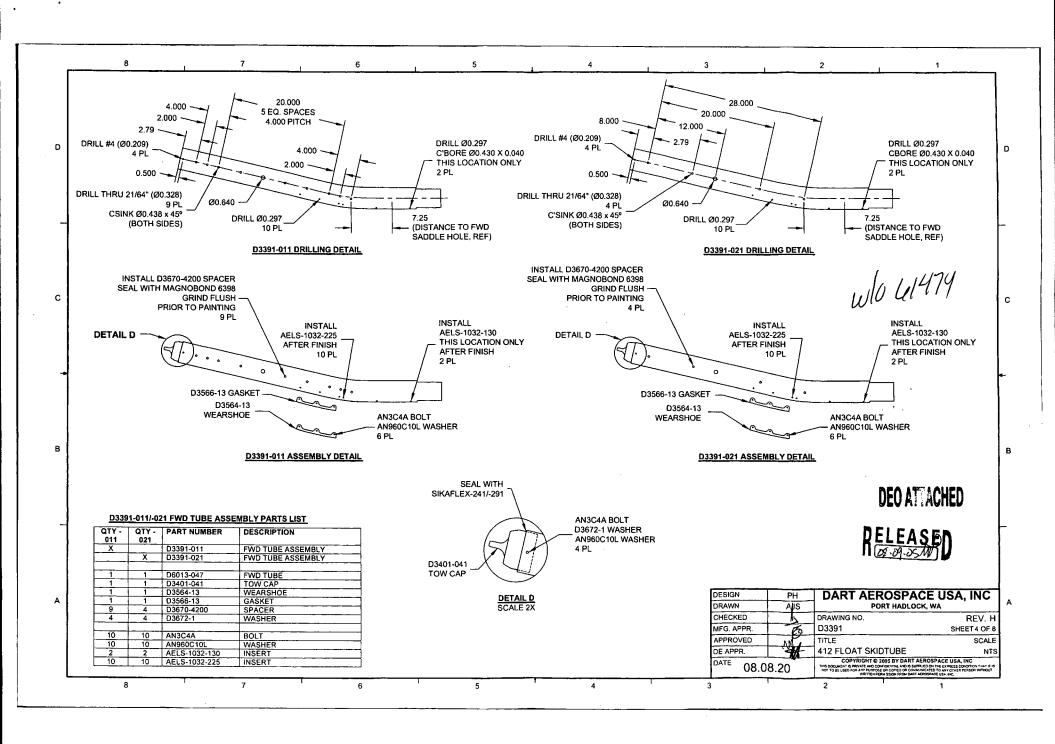
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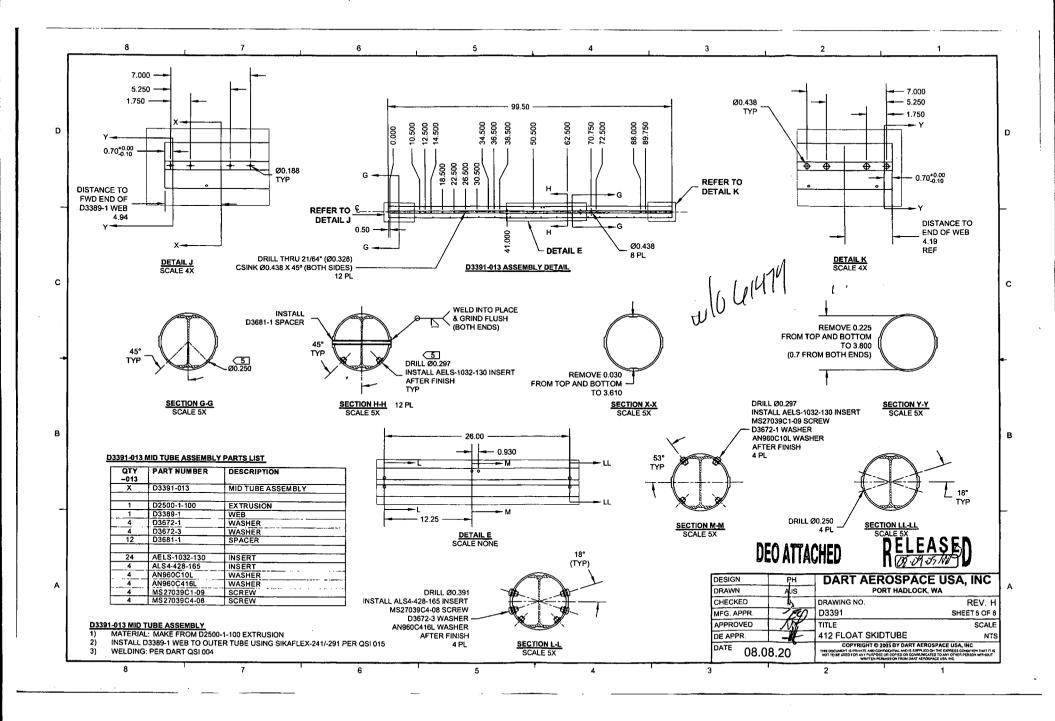
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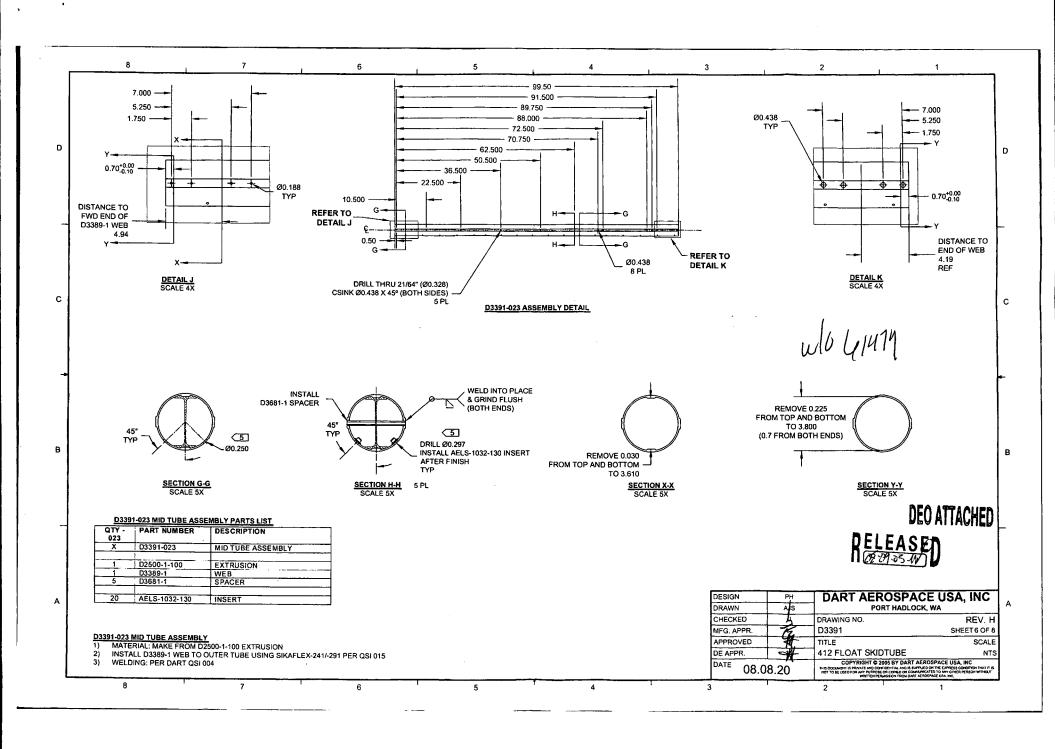
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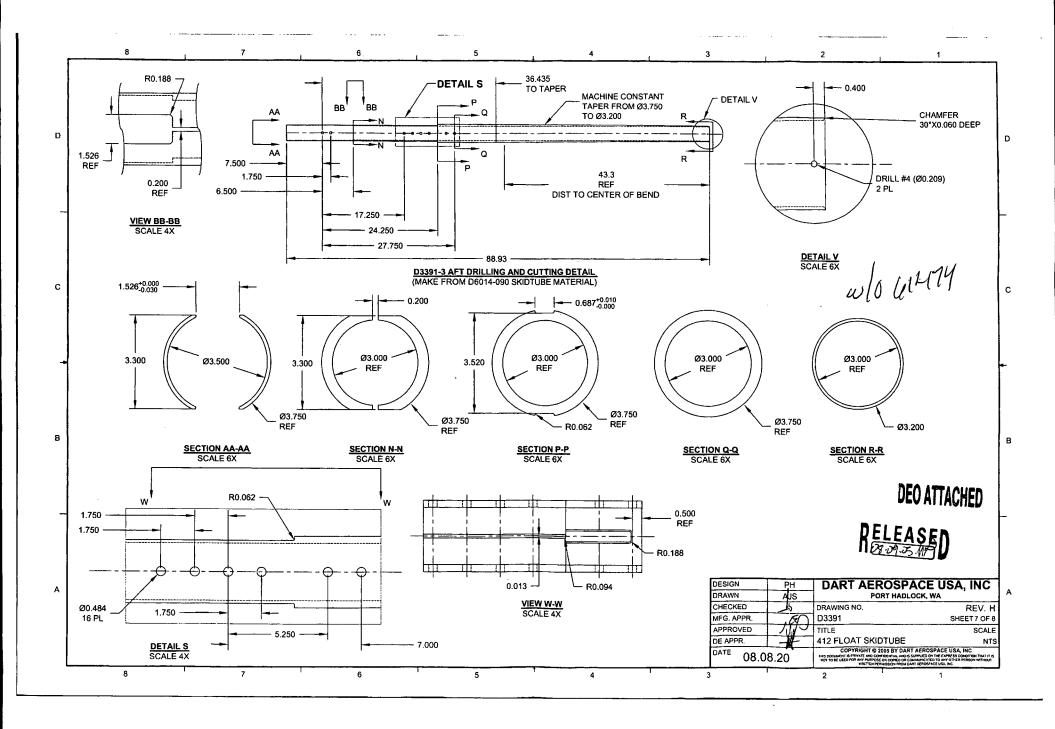
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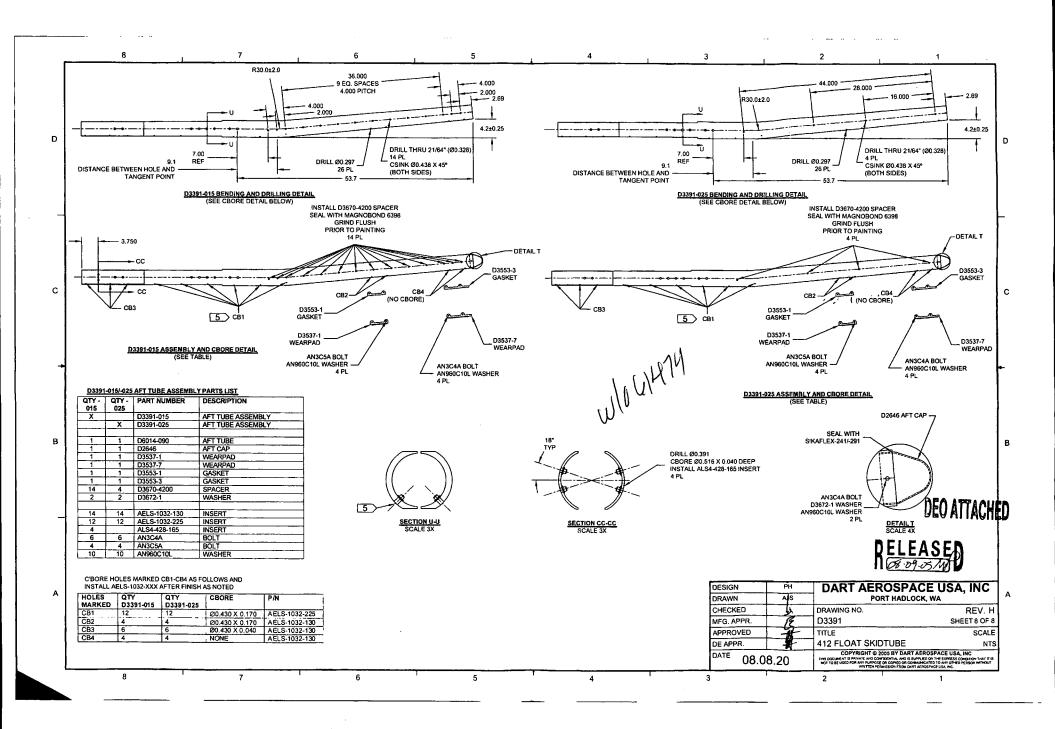
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

DRAWING N	10.	TITLE		REV. H	DART AEROS	SPACE USA, I	NC D.E.O. NO.		SHEET NO.	SCALE
D3391		412 FLOAT	SKIDTUBE	1	ENGINEER	RING ORDER	D3391-H-1	s	HEET 1 OF, 1	NTS
DRAWN	- a		CHECKED	ly .	MFG. APPR.	Ŋ	APPROVED MA	DE AI	PPR	
DATE	09.09.	23	DATE	04.04.24	DATE 09	109125	DATE 09/09/2	DATE	09/09	30

#### **PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

#### CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

DELEASED 2010 -02- 0 2

AMP.

w/6 41979

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Categ	ory:	NCR	: Yes N	lo <b>DQ</b>	<b>4</b> :	_ Date: _		
	R	esolution:	tion: Disposition: (				sed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC	<u> </u>		tion B	Cian 0	Verific		Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector	
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